Work Orde Wednesday, June								AS	AP		 Page 1
Item ID: Revision ID:	D3255-041			Accept				s	etup S	tart	
•	Access Panel A	assembly							S	top	
Required Date:	6/1/2011 6/2/2011	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item I Customer:	D:					
Approvals:	Process Plan	n: MF	Date: (-06-01	Tooling	De	nte:		R	un S	tart	
Approvats.			Date:	SPC (Y/N):		ite:			S	top	
Sequence ID/ Work Center ID		Operation Description	`	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reje Num	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3255	Rev I	В									
100 Large Fab Large Fab		Large Fab Memo 1-Weld as p	er Dwg D3255 ***purge w	0.00 0.00 eld***DA/R SS RO	D ·			66	1:06	.01_	
QC Quality Control	·	QC10- Inspect visual per	□2-Grind \ □2-Grind \ □ QSI004- ground welds	0.00	(060)				and the second s		
120 QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00	106/01			-04 -04)		

W/O:	-	WORK ORDER CHANGES												
DAŢE	STEP	PROC	EDURE CHANG	E		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		` .												
Part No	•	PAR #:	Fault Categor	y:	NÇI	R: Yes N	lo DQA	\:	Date:	· ·				
	R	esolution:	Disposition: _		QA:	N/C Clo	sed:		Date:					
NCR:	•	WORK ORDER NON-CONFOR					-	r						
DATE	STEP	Description of NC Section A	Co Initial Chief Eng	rrective Action Se Action Description Chief Eng	ection B	Sign & Date	Verific Section		Approval Chief Eng	-Approval QC inspector				
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Work Ord Wednesday, Jun						The state of the s	**************************************	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1				Page 2
Item ID: Revision ID:	D3255-041			Accept					Setup	Start		
Item Name:	Access Panel	Assembly								Stop		
Start Date: Required Date:	6/1/2011 : 6/2/2011	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item I Customer:	D:						
Reference:		,	1186183 1181 1188	l	customer.							
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:		I	Run	Start		
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop		
Sequence ID/ Work Center I	D.	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejo Qty		•	isp. tamp
Powder Coating		Grey Sandtex(Ref:4.3.5.6 Memo START TIM	E: 8-1	0.00 5 0.00 COVEN TEMPERATU	RE:			X	Ĵ	11	ml	1/0
11151	28	3200F	DFINISH TIME:	945							-	
140		QC3- Inspect Part Finish		0.00					B	11	-6-2	
QC		Memo		0.00				•	• •	•		

150

Quality Control

Small Fab

0.00

50 u/o c/os 0

Small Fab

0.00

Small Fab

1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg D3255DA/R 736 DOW CORNING ADHESIVE Batch: MI 1664

W/O:			V	VORK ORDER CHANG	ES	*****			
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		·							
Part No		PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:	
		esolution:	_ Disposit	ion:	_ QA: N/C C	losed:		Date: _	
NCR:			ORK OR	DER NON-CONFORMA	NCE (NC	R)			-
	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign	& Sect	cation	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date				

Work Order ID 70231

Wednesday, June 01, 2011 11:06:37 AM



Page 3

Item ID:

D3255-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Access Panel Assembly

Start Date: 6/1/2011 Required Date: 6/2/2011

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date: ____

Tooling: SPC (Y/N): Date:

Run

Start



Stop

Sequence ID/ **Work Center ID**

160

OC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

5 wolds

Tool ID Tool # Plan

Date:

Accept Qty Code

Reject Qty

Reject Number Stamp

Insp.

170

1.00

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

PM 70233

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

M 14 17 70 M

Duit AC	ospace i	h tu							
W/O:			WO	RK ORDER CHANG	GES	•			
DATE	STEP	PRO	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA	\:	Date: _	
	Res	solution:	Disposition):	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NCF)			
5475	0750	Description of NC			ction B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
		•							
	-								

Picklist Print

Wednesday, June 01, 2011 11:06:34 AM

Work Order ID: 70231

Parent Item: D3255-041

Parent Item Name: Access Panel Assembly

Start Date: 6/1/2011

Start Qty: 1.00

Required Date: 6/2/2011

Required Qty: 1.00

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IPP Rev:C

Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

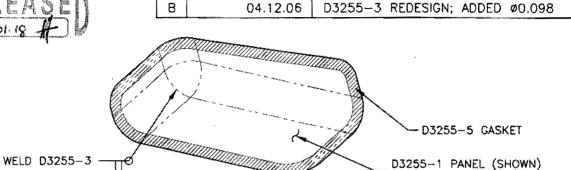
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3255-1		Manufactured	No			100	Each	6.0000	1	16/	/1.06.0	2/
	e e			Location		Loc (<u>Otv</u>	Loc Code				
				WA			6				_	
					68782		6		1	<u>(U)</u>	-/	
D3255-3 Cap		Manufactured	No			150	Each	17.0000	1	1	Plu	06.01
				Location		Loc C	Qty	Loc Code				
				WA021			17				_	
		,			66812		17			<u>(1)</u>	_	
D3255-5 Gasket		Manufactured	No			100	Each	14.0000	1	Sis	1166	/s7
				Location		Loc C	<u> 2ty</u>	Loc Code				
				GA			14				_	
					66574		2				-	
					68783		12			•		

Page 1

	1												
W/O:			V	ORK ORDER	CHANGES								
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	•	PAR #:	Fault Ca	tegory:	NO	R: Yes	No DQ	A:	Date:				
	R	esolution:	Disposit	ion:	Q/	A: N/C Ck	osed:		Date: _				
NCR:		1	WORK ORDER NON-CONFORMANCE (NCR) Corrective Action Section B										
DATE	STEP	Description of NC					cation	Approval	Approval				
DAIL	J 1 1	Section A	Initial Chief Eng	Action De Chief		Sign & Date	Sect	ion C	Chief Eng	QC Inspector			
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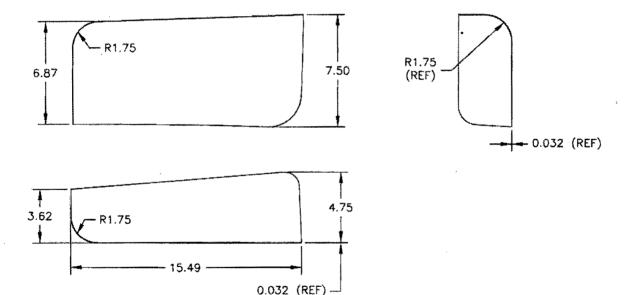


	DESIG	N N	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
	CHECI	KED O	APPROVED	DRAWING NO.	REV. B
		u'	di-	D3255	SHEET 1 OF 4
	DATE			TITLE	SCALE
	04.1	12.06		ACCESS PANEL ASSEMBLY	1:6
_	Α		04.01.27	NEW ISSUE	
		l	**************************************		



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)

D3255-2 PANEL (OPPOSITE)



D3255-1 BEND DETAIL D3255-2 OPPOSITE

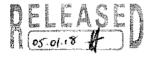
D3255-041/-042 NOTES: 1) WELD PER DART QSI 004

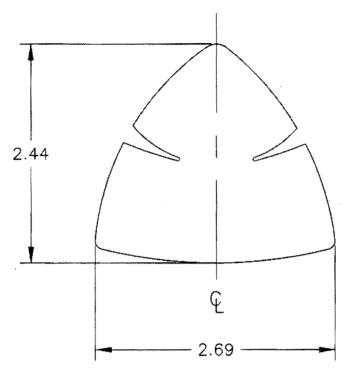
- 1) WELD PER DART QSI 004 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

	Topass												
W/O:			W	ORK ORDER CHANGI	ES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	*	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	:	Date: _					
	Re	solution:	Disposition	n:	QA: N/C Cld	sed:		Date:					
NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC		Corrective Action Section		Verifica	ation	Approval	Approval				
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio	n C	Chief Eng	QC Inspector				
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DATE	4/	TITLE	SCALE
04.12.06		TITLE	1:1





D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

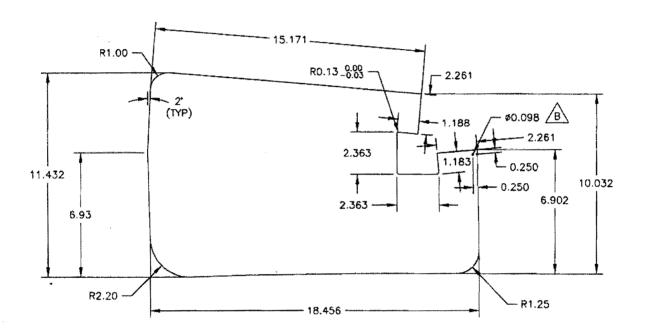
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

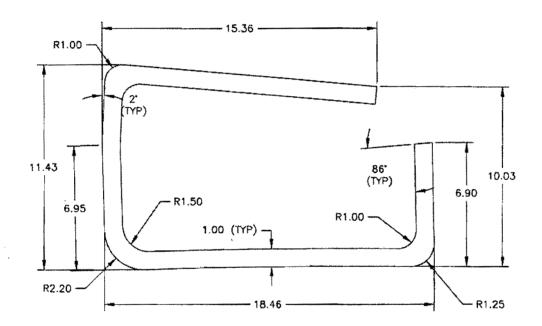
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description		on B		ication	Approval Chief Eng	Approval QC inspector
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DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

D3255-5 NOTES:

1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP Description of NC Section A	Description of NC		Corrective Action Section B			Verification Approval		Approval
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